



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3171-3
Job Sheet 210458



Part No: D3171-3

Job Qty: 2 pcs

Part Name: Angle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/9/20

Job Tracking No:

Due Date: 6/12/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B SHEET 2 IPP REV:A 16-11-10 AS PER DWG REV.B DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	2	6/11/20	6/11/20	0.17	0.31	Waterjet - Flow		a 20/06/10
		pcs					Waterjet - Omax		
120	QC 8	2	6/11/20	6/11/20	0.00	0.00	QC 8 - 12		DAS JUN 10 2020 40 39
		pcs					QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

Plex 6/9/20 3:24 PM Dart.lajeunesse.marie

				QC 8 - 82		
130	Small Fab - Brake NC - B4B	2 pcs	6/12/20	0.25 0.10	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	JUN 11 2020
150	QC 5	2 pcs	6/12/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	JUN 12 2020 40 9-89
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
160	Packaging 3-1 - Stock - B4B	2 ✓ pcs	6/12/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS 80 9-89
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	JUN 12 2020
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Plex 6/9/20 3:24 PM Dart.lajeunesse.marie	

				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
170 QC 21 - SA	2	6/12/20	0.00 0.00	QC 21 - SA - 21	DAS
	pcs			QC 21 - SA - 70	21
				QC 21 - SA - 9	9-89

JUN 12 2020

Part Op 100 - 1-Cut as per Dwg D3171

Descriptions: 120 - QC8- Inspect parts - second check

130 - Form as per dwg - Bend as per Dwg D3171

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location:

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S24GA	304/316 .025 Sheet	.0422 sf (.0211 ea)	100-Waterjet - Flow - 1	5232321

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S24GA	0	59	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Angle	0.257Inches + 0.006 - 0.001	0.263 0.256	Ø	Diameter
2	Angle	0.500Inches + 0.006 - 0.001	0.506 0.499	Ø	Diameter
3	Angle	0.400Inches ± 0.030	0.430 0.370		
4	Angle	0.590Inches ± 0.010	0.600 0.580		
5	Angle	1.180Inches ± 0.030	1.210 1.150		
6	Angle	2.580Inches ± 0.030	2.610 2.550		
7	Angle	0.025Inches ± 0.010	0.035 0.015		
8	Angle	1.587Inches ± 0.010	1.597 1.577		

Plex 6/9/20 3:24 PM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S282284



Part: D3171-3

Job No: 210458

Serial No/Batch: S282284

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/10/20